

ABSTRACT

A flange corner forming apparatus includes a die having a planar upper surface upon which a workpiece may be supported and side surfaces intersecting at a flange forming corner. A workpiece clamps the workpiece securely against the die with the flange corner of the workpiece extending along the corner of the die, and a forming roll cooperatively configured with respect to the flange forming corner and form the flange of the workpiece about the die corner. A wedge is movable between the workpiece and the die corner to support the flange as it is being formed by the roll. A controller controls the movement of the wedge, the forming roll and the clamp.